

Work Order ID 132490

132490

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May-07-15 2:47:24 PM

Item ID: D412-724-043 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Head Rest Assembly, LH
 Start Date: 4/29/15 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 5/07/15 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: MLS Date: MAY 11 2015 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D412-724	Rev a

100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo <u>M. LL.</u>	0.00							
Doc.Control -USB or Paperwork									
If D412-724-043 is a W/O on it's own, Photocopy bluefile and create labels per PPP D412-724-043 CHG001									

MLS 1506-30
 DAS 02 9-89
 JUL 06 2015

110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							

1X
 DAS 28 9-89
 JUN 01 2015
 JUL 06 2015

120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							

DAS 02 9-89

Quality Control

JUL 06 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
☐ OTHER : _____					

Work Order ID 132490

132490

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May-07-15 2:47:24 PM

Item ID: D412-724-043

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Head Rest Assembly, LH

Stop ***NS2***

Start Date: 4/29/15 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 5/07/15 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									DAS
Packaging	Memo	0.00							02
Packaging	Identify and pack for shipping as per PPP D412-724-043 Location <u>6607</u> PPP Rev: _____								9-89
									JUL 06 2015
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

ML5 JUL 06 2015

ML5 JUL 06 2015

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
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Root Cause		FAULT CATEGORY			
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☐ OTHER : _____					

May-07-15 2:47:24 PM

Parent Item: D412-724-043

Parent Item Name: Head Rest Assembly, LH

132490

D412-724-043

Start Date: 4/29/15**Required Date:** 5/07/15**Start Qty: 1.00**

Required Qty: 1.00

Comments: IPP Rev:A04.09.08New IssueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN525-10R6 Screw		Purchased	No			120	Each	98.0000	4	4			
AN525-10R6 DAS 02 9-89 Location ST329 M130325 M131420 Loc Qty 98 4 94 Loc Code													
D3303-041 Head Rest		Manufactured	No			120	Each	7.0000	1	1			
D3303-041 DAS 02 9-89 Location ST457 127541 130536 Loc Qty 7 4 3 Loc Code													
D3304-043 Tube Assembly		Manufactured	No			120	Each	0.0000	1	1			
D3304-043 DAS 02 9-89 Location ST457 127541 130536 Loc Qty 7 4 3 Loc Code													

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

3.0 INSTALLATION PROCEDURE

To install a Dart Head Rest Assembly:

- 3.1 If installed, remove the existing Head Rest Assembly by pulling the quick release pin that attaches it to the seat. Make note of the installation position (if applicable).
- 3.2 Inspect the seat for damage in the vicinity of the Head Rest Assembly. Consult the Aircraft Maintenance Manual for disposition if damage is observed.
- 3.3 If only replacing the Head Rest with the equivalent Dart D3303-041 Head Rest, separate the existing Head Rest from the existing Tube Assembly by undoing 4 screws. Re-assemble D3303-041 Head Rest with existing Tube Assembly by installing 4 screws and tightening to 15-25 in lb.
- 3.4 If only replacing the Tube Assembly with a Dart D3304-041/-043/-044 Tube Assembly, separate the existing Head Rest from the existing Tube Assembly by undoing 4 screws. Re-assemble existing Head Rest with Dart D3304-041/-043/-044 Tube Assembly by installing 4 screws and tightening to 15-25 in lb.
- 3.5 Slide the new or modified Head Rest Assembly into the seat tube and lock in place at the same location that the old Head Rest Assembly was installed (if applicable) using the quick release pin. Ensure pin is properly engaged.

4.0 WEIGHT AND BALANCE

There is negligible weight change associated with the installation of the Dart Head Rests.

5.0 PARTS LIST

QTY -011	QTY -041	QTY -043	QTY -044	Part Number	Description
X				D412-724-011	Dart Replacement Head Rest Kit, for 205/212/412
2	X			D412-724-041	Head Rest Assembly, Center
1		X		D412-724-043	Head Rest Assembly, LH
1			X	D412-724-044	Head Rest Assembly, RH
	<i>me</i>	1	1	D3303-041	Head Rest
	1			D3304-041	Tube Assembly
		1		D3304-043	Tube Assembly
			1	D3304-044	Tube Assembly
	4	4	4	AN525-10R6	Screw